

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008836**Date Inspected:** 27-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	CWI: Chen Ying Xin/Liu Xiao Zhong			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower components		

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

SAW Process:

Repair welding of weld Joint# 85B located on PCMK NSTL3-3 B/K. Welder is identified as 040460. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SAW-1G(1F)-Repair.

FCAW Process:

Repair welding of weld Joint# 85B located on PCMK NSTL3-3 B/K. Welder is identified as 066733. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-1G(1F)-Repair.

Repair welding of weld Joint# 85B located on PCMK NSTL3-3 B/K. Welder is identified as 053870. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-1G(1F)-Repair.

Repair welding of weld Joint# 85B located on PCMK NSTL3-3 B/K. Welder is identified as 048627. ZPMC QC is

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identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-1G(1F)-Repair.

SMAW Process:

Non critical repair welding of North Tower Lift 2 skin A. Welder is identified as 056200. ZPMC QC is identified as Gao Zhi Chun. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-4G 4(F)-Repair.

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld Joint# 84B located on PCMK WSTL3-4 B/C. Welder is identified as 058792. ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F.

Welding of weld Joint# 12 located on PCMK WSD1 FASA4-2 B/E. Welder is identified as 070212. ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Welding of weld Joint# 15 located on PCMK WSD1 FASA4-2 B/E. Welder is identified as 066882. ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

Summary of Conversations:

No relevant Conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
